

Work Order ID 57786

April 14, 2010 3:00:54 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 14/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 05/05/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

BP

Date: *10-4-14* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A *[Signature]*

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend I

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

[Signature] *10-4-26*

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

Accept

**Setup Start**

Stop

**Cust Item ID:**[illegible]

Customer:

Reference:

Run Start

Stop

Operation Description

Set Up/ Run Hours

**Draw
Number**

**Draw
Rev.**

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

120

0.00

Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

W/O:			WORK ORDER CHANGES					
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R□□□ Aluminum Rod

m113207

BE 10/04/27

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R□□□ Aluminum Rod

m113207

BE 10/04/27
MB 10/04/29

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

3 BE 10/04/30

W/O:			WORK ORDER CHANGES					
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Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	81064/30						
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	81064/30						
170 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.	0.00 0.00	= 7 m-1/2				10/05/03		

W/O:			WORK ORDER CHANGES					
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M114207
11:45am
320°C
1

=> M 10/05/03

1 0

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> M-1 10/05/04 (1X)

W/O:			WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☐ ☐ ☐ ☐ M112429

Sikaflex expire date: 10/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ ☐ ☐ ☐ M112429

Sikaflex expire date: 10/08

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch:

M113545

M-1 10/05/04

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Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

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--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location:

PPP Rev:

PP 57027

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Rev 10/5/13

10/05/17

P10-5-B

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 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev: P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 14/04/2010

Required Date: 05/05/2010

Start Qty: 1.00

Required Qty: 1.00

D2580-1 Manufactured No 110 Each 3.0000 1.0000



205 Skidtube bent detail

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

57028

57188

B57935
 2
 1

10-4-26

D2576-3 Manufactured No 140 Each 121.0000 1.0000



Step (maching detail)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

46661

52215

121

73

48

~~1~~

1

BE 10/04/27

D2579 Manufactured No 140 Each 113.0000 20.0000



Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

57052

113

113

~~1~~

B57348

B

BE 10/04/27

12

BE 10/04/27

W/O:			WORK ORDER CHANGES					
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IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 14/04/2010

Required Date: 05/05/2010

Start Qty: 1.00

Required Qty: 1.00

D2855 Manufactured No 200 Each 118.0000 1.0000



Cap

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP6	2	
56613	2	
Main Warehouse		
ST026	116	
50513	1	
50770	30	
51539 ✓	31	
53791	54	

AN3-5A Purchased No 200 Each 1,017.000 2.0000



Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST350	1017	
105057 ✓	1017	

10/05/04
IX m-k
2x m-k 10/05/04

April 14, 2010 3:00:59 PM

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 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 14/04/2010

Required Date: 05/05/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L

Purchased

No

200

Each

4,591.000 2.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST348

4591

110985

4591

ALS7-1032-130

Purchased

No

200

Each

359.0000 50.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST282

359

113238

359

AN3C4A

Purchased

No

200

Each

1,449.000 50.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST350

1449

113226

50

114103

501

114108

400

114330

498

10/05/04

2x m-l

50 x m-l
10/05/04

50 x m-l
10/05/04

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Start Date: 14/04/2010

Required Date: 05/05/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C10L

Purchased No

200

Each

0.0000

50.0000



NAS1149C0332R

M114341



50X M-L
10/05/04

washer

D3566-13

Manufactured No

200

Each

52.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

53461

52

52

200

Each

10.0000

1.0000

D3566-5



Gasket

10/05/04
1X M-L

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP015

56829

10

10

B57526

1X M-L
10/05/04

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 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 14/04/2010

Required Date: 05/05/2010

Start Qty: 1.00

Required Qty: 1.00

D3566-1 Manufactured No 200 Each 25.0000 2.0000
 Gasket

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP015	25	
56825	3	
57257	22	

B57715

2x m. l w/05/04

D3564-11 Manufactured No 200 Each 14.0000 1.0000
 Wearshoe

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP019	14	
Main Warehouse		
FP19	14	
56834	1	
57259	13	

✓

10/05/04

1x m. l

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Start Date: 14/04/2010

Required Date: 05/05/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-13

Manufactured No

200

Each

21.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

3

56285

3

Main Warehouse

FP17

18

56533 ✓

18

D3564-9

Manufactured No

200

Each

12.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

1

55334

1

Main Warehouse

FP019

11

57260 ✓

11

10/05/04

1x m.h

10/05/04

1x m.h

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Start Date: 14/04/2010

Required Date: 05/05/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-5 Manufactured No 200 Each 12.0000 1.0000



Wearshoe

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
OFFSHORE	B 57525	
FG	2	
34806	2	
Main Warehouse		
FP	10	
55024	1	
55333	9	

1x m-h
 10/05/04

D2594-3 Manufactured No 200 Each 204.0000 16.0000



O-Ring, 205 Skidtube

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FP	204	
55546	204	

B 58191

16x m-h
 10/05/04

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DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 14, 2010 3:00:59 PM

Page 8

Work Order ID: 57786



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 14/04/2010

Required Date: 05/05/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

200

Each

411.0000

16.0000



Plug, 205 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

42807

55002

411

112

299

1357826

16X: M-h
10/05/04

April 14, 2010 3:00:59 PM

Shop Packet Print

Page 8

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY SCALE NTS	
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *57786*
BS10-414

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
07-06-28-11

Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576

#0.208
DRILL PRIOR TO D2855 CAP
INSTALLATION (2 PLACES)

AN3-SA BOLT (1)
AN960J10L WASHER (1)
(2 PLACES)

D2855 CAP

SEAL WITH
SIKAFLEX-2+1/-29

0.40

Diagram illustrating the components of a wheel assembly:

- D2579 SPACER
- D2596 WEB (REF)
- ALS7-1032-130 (REF) (TYP 50 PLACES)

Diagram illustrating the steps for AFTER PERFO:

1. CHA
2. INS
3. WE
4. C.B

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

Technical drawing of a skid plate assembly, showing side and cross-sectional views with dimensions and material specifications.

Side View Dimensions:

- Overall length: 1.5
- Overall width: 0.5
- Internal width segments: 1.5, 1.5, 1.5, 1.5, 1.5, 1.5, 1.5, 1.5
- Internal width segments: 1.5, 1.5, 1.5, 1.5, 1.5, 1.5, 1.5, 1.5

Material and Finish Specifications:

- BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE
- BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE
- WELD AS PER DETAIL B

Assembly Details:


- REFER TO DETAIL C
- AN3C4A BOLT (1)
- AN960C10L WASHER (1)
- (50 PLACES)

Part Numbers:

- D3566-1
- D3566-5
- D3566-1
- D3566-13
- D3564-11
- D3564-5
- D3564-9
- D3564-13

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DRAWN BY	PH
APPROVED	H

 DART AEROSPACE LTD. MISSISSAUGA, ONTARIO, CANADA	
DRAWING NO.	REV. D
D2580	SHEET 2 OF 3
TITLE	SCALE
205 SKIDTUBE ASSEMBLY	1:24

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
07 Dec 28

Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576

DRILL PRIOR TO D2855 CAP
INSTALLATION (2 PLACES)

SEAL WITH
SIKAFLEX-241/-291

AN3-5A BOLT (1)
AN960JD10L WASHER (1)
(2 PLACES)

SEE NOTE

D2855 CAP

0.40

0.208

[illegible]

w/o 57786

37.50
DISTANCE TO AFT END
OF D2596 WEB
3 7
1.750 1.750
#0.508 (TYP.)
(40 PLACES)
REFER TO DETAIL E
REFER TO DETAIL A
8.750
17.375
26.000
34.188
57.313 (REF)
7 EQUAL SPACES
8.188 PITCH
38.0
91.500
190.0
(D2500-1)

Technical drawing of a horizontal curve showing dimensions and callouts. The drawing includes a horizontal line representing the curve, with various dimensions and callouts. Key dimensions include: 5.985, 5.338 (REF), 51.340, 39.580, 5.915, 3.630 (REF), 20.0, 1.4, 1.0, 13.4, 32.0 ± 1.0, and 11.0. Callouts include '4' (twice), '0.640', '0.508 (8 PLACES)', and 'DISTANCE BETWEEN HOLE AND TANGENT POINT' (twice).

WELD AS PER DETAIL F

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

NO C'BORE NO PLUG

REFER TO DETAIL G

0.5

1.5

1.5

H

P

H

P

P

P

P

P

P

8

1.5

1.5

1.5

NO C'BORE NO PLUG

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)

AN96OC10L WASHER (1)

(50 PLACES)

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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PU

CHECKED *ld*

DATE _____

07.02.27

P.

APPROVED

PART

DRAWING NO.

TITLE

205 SKIDTUBE ASSEMBLY

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

REV. D

SHEET 3 OF 3

SCALE

1.84

W/O:			WORK ORDER CHANGES					
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NOTE: Date & initial all entries

NO. 220

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 576830
Part number: D205-634.041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 10.04.27

Welder [Signature] Date of Test Coupon 10.04.27

The above named individual is qualified in accordance with AWS D17.1.2001 to weld